

## ABSTRACT OF THE DISCLOSURE

A grinding wheel having a tool portion formed by firmly fixing diamond grains to an end face of a cup-shaped core by brazing. A circumferentially continuous groove is formed in a substantially central portion of the end face of the core. The abrasive grains are firmly fixed to an end face portion excluding regions near an outer rim and near an inner rim of the end face and near the boundaries with the groove under the condition that, with respect to all the abrasive grains, skirts of a brazing material layer for holding the abrasive grains have a length one or more times an average grain size of the abrasive grains. The provision of the groove in the end face of the core can enhance the capability of ejecting chips that occur during machining; besides, chips can be captured into the groove to preclude the occurrence of scratches resulting from the chips. Moreover, sufficient lengths of skirts of the brazing material layer are secured for all the abrasive grains arranged on the end face of the core, which improves the force for holding the abrasive grains and avoids grain fall-out during machining.